

Work Order ID 70910

Friday, June 17, 2011 7:42:32 AM



Page 1

Item ID: D3023-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Back Panel

Start Date: 6/16/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date: 6/16/11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3023

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

2024 .037

1-Cut as per Dwg D3023

Dwg Rev: A

Prog Rev: A

***graind direction along 28.100" ***

2-Deburr if necessary

11-7-11

(2)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

11-7-11

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Customer:

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Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

0.00

8 u167/4

②

Memo

130



Brake NC

Brake NC

NC BRAKE

0.00

0.00

Memo

1-Bend as per Dwg D3023 2-form edge of back pan as per dwg D3023 using
D3017-041 back frame

8 u167/4

②

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

8 u14/23

②

Memo

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Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

N/A
now done on assy D350.68901/043

160

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Setup Start



Revision ID:

Stop



Item Name: Back Panel

Start Date: 6/16/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

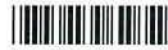
Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

Identify as per dwg & Stock Location: *W/A*

0.00



Packaging

Memo

0.00

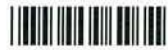
Packaging

*12**11-11-23*

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*11/11/23**11-11-23*

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Picklist Print

Friday, June 17, 2011 7:42:39 AM

Page 1

Work Order ID: 70910



Parent Item: D3023-1



Parent Item Name: Back Panel



Start Date: 6/16/2011

Required Date: 6/23/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP C 02.01.23 Revised NG
IPP Rev:D 08-04-16 now water jet DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.032  2024-T3 .032 sheet		Purchased		No		100	sf	24.4000	2.8777 	3.029158	6.5		
B11-7-11													

Location

Loc Qty

Loc Code

MAT22

24.4

111699

0.5

113189

23.9

118243

118243

2

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	70910
Description: Back Panel		Part Number:	D3023-1
Inspection Dwg: D3023 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	.131	0		V BoZ	
Ø0.191	+0.005/-0.001	.193	2		V	
1.660	+/-0.010	1.660	>		V	
0.375	+/-0.010	.374	2		V	
1.340	+/-0.010	1.341	+		V	
2.375	+/-0.010	2.373	L		V	
0.375	+/-0.010	.373	2		V	
25.28	+/-0.030	25.25	L		T BoZ	
27.03	+/-0.030	27.03	2		T	
28.10	+/-0.030	28.10	2		T	
1.30	+/-0.030	1.298	2		V	
2.375	+/-0.010	2.374	2		V	
8.711	+/-0.010	8.711	2		T	
5.597	+/-0.010	5.597	0		V	
8.57	+/-0.030	8.57	+		T	
1.970	+/-0.010	1.967	2		V	
7.42	+/-0.030	7.42	+		V	
10.92	+/-0.030	10.92	?		T	
14.75	+/-0.030	14.75	1		T	

Measured by: RB	Audited by: J	Prototype Approval:	N/A
Date: 11-7-11	Date: 11/6/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.11.27	New Issue	KJ/EC	AS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

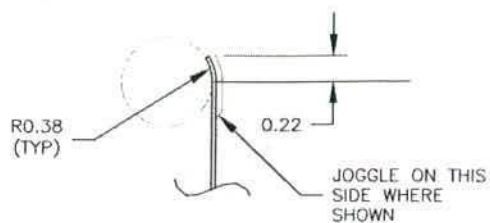
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

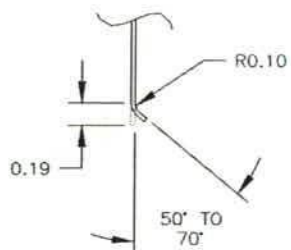
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SECTION A-A
SCALE 1:1
(TYPICAL, EXCEPT WHERE SHOWN)

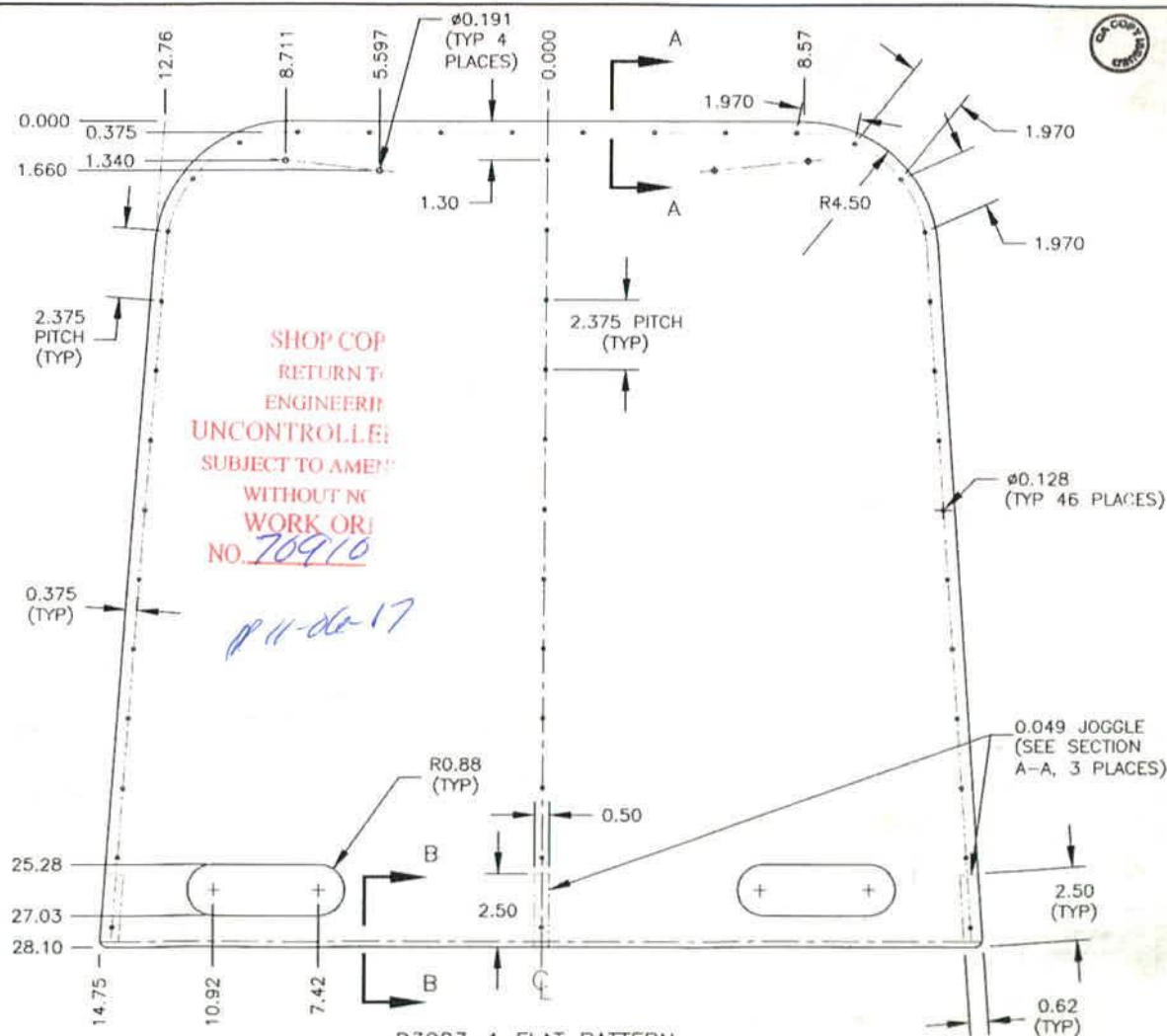


SECTION B-B
SCALE 1:1
(BOTTOM EDGE ONLY)



RELEASED
9.06.07

D3023-1 BEND DETAIL



D3023-1 FLAT PATTERN

D3023-1 BACK PANEL:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES.
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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A	01.05.18	NEW ISSUE	
DESIGN	CP	DRAWN BY	CP
CHECKED	#	APPROVED	#
DATE	01.05.18	TITLE	BACK PANEL
		DRAWING NO.	D3023
		REV. A	SHEET 1 OF 1
		SCALE	1:4

DART

DART AEROSPACE LTD.
HAMMERSLEY, ONTARIO, CANADA

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